



7355

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6505G00231-3T

Job Sheet 187060



Part No: RBW6505G00231-3T

Job Qty: 1 ea

Part Name: AW139 Tail Rotor Gear Box Seal Replacement Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/27/18

Job Tracking No:

Due Date: 12/28/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBW6505G00231-3T Rev 3 IPP Rev A 18.02.07 New issue DP verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		12/28/18	0.00	0.00	Start Up Small Fab-4		MLL
110	Small Fab	1 pcs		12/28/18	0.00	1.00	Small Fab-4		MLL DAS
120	QC	1 pcs		12/28/18	0.00	0.00	QC4		38
130	Packaging	1 pcs		12/28/18	0.00	0.00	Packaging3-1		DAS 28 7-89
140	QC21-FG	1 Ea		12/28/18	0.00	0.00	QC21		28 9-89

Part Op 110 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
Descriptions: APP-IM2700-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard
RBW6505G00231-3T-15 to RBW6505G00231-3T-13 foam as per DWG. 6-Glue foam to case and pack case as per
DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	90-Start up Operation	
APP-IM2700-E	Case	1 Ea (1 ea)	110-Small Fab	5113448
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	110-Small Fab	5124755
RBW6500X01611-W142H-3T	Tail Rotor Gear Box Output Oil Seal Removal & Press Tool	1 Ea (1 ea)	110-Small Fab	5021040
RBW6505G00231-3T-11	Bottom Tool Cushion use in case APP-IM2700-E	1 Ea (1 ea)	110-Small Fab	5018054 5134691
RBW6505G00231-3T-13	Top Tool Cushion use in case APP-IM2700-E	1 Ea (1 ea)	110-Small Fab	5124756
RBW6505G00231-3T-15	Inside Placard	1 Ea (1 ea)	110-Small Fab	5124757
RBW6522A00231-W142AJ-3T	Tail Rotor Gear Box/Servo Actuator Oil Seal Fit/Extracting Tool	1 Ea (1 ea)	110-Small Fab	512196
RBW6522A00231-W142AK-3T	Tail Rotor Gear Box/Mast Output Oil Seal Assembly Press Tool	1 Ea (1 ea)	110-Small Fab	5140705
RBW6522A00231-W142S-3T	Tail Rotor Gear Box/Mast Output Oil Seal Assembly Support Tool	1 Ea (1 ea)	110-Small Fab	5061472
				506102

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	97524A032	4	671	0
110-Small Fab	APP-IM2700-E	1	6	0
	RB41011	1	690	0
	RBW6500X01611-W142H-3T	1	1	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

RBW6505G00231-3T-11	1	2	0
RBW6505G00231-3T-13	1	2	0
RBW6505G00231-3T-15	1	2	0
RBW6522A00231-W142AJ-3T	1	1	0
RBW6522A00231-W142AK-3T	1	4	0
RBW6522A00231-W142S-3T	1	4	0
Part Specifications			
Specifications could not be found.			

Plex 11/27/18 10:45 AM Dart.lajeunesse.marie



DART
AEROSPACE

Dart Aerospace Ltd.
1270 Aberdeen Street,
Hemel Hempstead, ON K5A 1K7
CANADA
TEL: 1 813 632-5200
FAX: 1 813 632-5201
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S142598



Part: RBW6505G00231-3T

Job No: 187060

Serial No/Batch: S142598

Revision: 3

Inspector:

Exp Date:

Instructions:

Date: 01/08/19

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

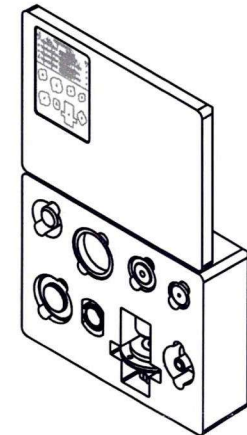
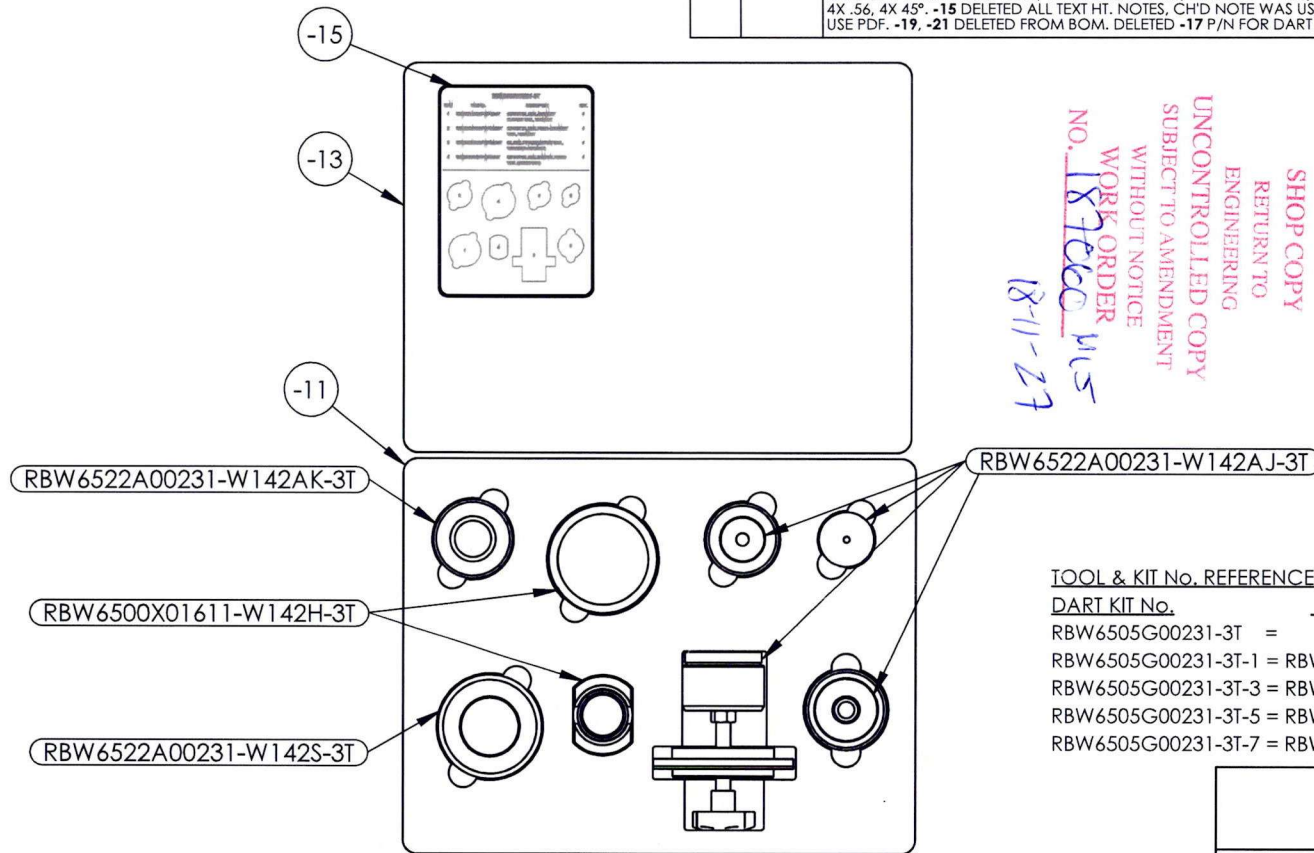
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-11 CH'D DEPTH WAS 3-1/2 IS 4-3/4, WAS 4-3/4 IS 5-9/16. -13 CH'D PLACARD LOCATION CUTOUT WAS HITTING TOOL WITH LID CLOSED.	10/2/2012	RJC	SE
2	15-0145	-11 ADDED MISSING DIM 8X R.13. -13 CH'D DIM WAS .07 IS .13. -15 REPLCED CONTENTS LIST WITH RBW6505G00231-3T, DELETED LINES FROM TOOL LAYOUT, ADDED ITEM NUMBERS TO TOOL LAYOUT. ADDED -19 AND -21.	6/23/2015	RJC	JAG
3	16-0254	-11, -13, -15 CH'D DWG. TO SHEET METAL TOLERANCE. -11, -13 CH'D MATERIAL AND VENDOR WAS Y20 BLACK I.R. SPECIALTY FOAM IS ETHAFOAM 220, BLACK (CASE SOLUTIONS). -11 CH'D DIM WAS 17.00 IS 17.15, WAS 22.00 IS 22.15, WAS 6.00 IS 6.08, WAS 4X 4" IS 4X 2". ADDED DIM 4X .65, 4X 45°. -13 CH'D DIM WAS 17.00 IS 16.96, WAS 22.00 IS 21.95, WAS 1.88 IS 1.83, WAS 4X 4" IS 4X 2", ADDED DIM 4X .56, 4X 45°. -15 DELETED ALL TEXT HT. NOTES, CH'D NOTE WAS USE PDF FOR MANUFACTURING IS USE PDF. -19, -21 DELETED FROM BOM. DELETED -17 P/N FOR DART PLACARD.	12/5/2016	RJC	JAG



TOOL & KIT No. REFERENCE

DART KIT No.	DART TOOL No.	ORIGINAL No.
RBW6505G00231-3T	=	3T6505G00231
RBW6505G00231-3T-1	=	RBW6522G00231-W142S-3T = 3T6522G00231-W142S
RBW6505G00231-3T-3	=	RBW6522G00231-W142AK-3T = 3T6522G00231-W142AK
RBW6505G00231-3T-5	=	RBW6522G00231-W142AJ-3T = 3T6522G00231-W142AJ
RBW6505G00231-3T-7	=	RBW6500X01611-W142H-3T = 3T6500X01611-W142H

DART AEROSPACE	
TITLE TGB SEAL REPLACEMENT TOOL KIT	
DWG NO. RBW6505G00231-3T	REV 3
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/✓	
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	AW139
SCALE 1:8	DATE 1/3/2009
SHEET 1 OF 4	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				1	TGB/MAST OUTPUT OIL SEAL ASSEMBLY SUPPORT TOOL		RBW6522A00231-W142S-3T	1
				1	OUTPUT OIL SEAL PRESS TOOL		RBW6522A00231-W142AK-3T	1
				1	TGB/SERVO ACTUATOR OIL SEAL FIT/EXTRACTION TOOL		RBW6522A00231-W142AJ-3T	1
				1	TGB OUTPUT OIL SEAL REMOVAL AND PRESS TOOL		RBW6500X01611-W142H-3T	1
		B/O	-9	1	CASE	BLACK PLASTIC	PELICAN #APP-IM2700-E	N/S
		B/O	-11	1	BOTTOM TOOL CUSHION	ETHAFOAM 220, BLACK	6.08 X 17.15 X 22.15 (CASE SOLUTIONS)	2
		B/O	-13	1	TOP TOOL CUSHION	ETHAFOAM 220, BLACK	1.83 X 16.96 X 21.95 (CASE SOLUTIONS)	3
			-15	1	INSIDE PLACARD	PLASTIC		4
		B/O		1	DART PLACARD	ALUMINUM	#RB41011	N/S